

Work Order ID 123523

123523

Page 1

Thursday, August 07, 2014 11:17:48 AM

Item ID: D4867-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 206L FWD Leg Assembly
 Start Date: 8/07/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/07/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 11-08-11 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4867	C

110

0.00

110

Small Fab

Small Fab

Memo

0.00

ALIGN PILOT HOLES IN D4867-1 WITH PILOT HOLES IN D4871-1 AND D4871-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG.
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9964 AS PER DWG.

2 FF NOV 28 2014

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.00

(2) DAS
38
9-89
NOV 28 2014

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Small Fab	Memo	0.00				2	FF		DEC 01 2014
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9964 A/R HYSOL BATCH: <u>M130450</u>								
140	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
140									
QC	Memo	0.00							
Quality Control									DEC 02 2014
150	Outsource process - Laser Marking	0.00							
150									
Outsource9	Memo	0.00							
Outsource process - Laser Marking	ISSUE P/O: <u>26707</u> OUTSOURCE VENDOR: P&L PRINTING ENGRAVE P# AS PER DWG C OF C IS REQUIRED								<u>CZ 14/12/03 2</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <i>St 133</i>	0.00							
180									
Packaging	Memo	0.00							
Packaging									

2x SP 15-01-7

(2)

2

CR 15-01-28

JAN 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MLJ 15-01-09

AB-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Training									
Transport									
Unapproved									

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Picklist Print

Thursday, August 07, 2014 11:17:48 AM

Page 1

Work Order ID: 123523

123523

Parent Item: D4867-041

D4867-041

Parent Item Name: 206L FWD Leg Assembly

Start Date: 8/07/14

Required Date: 8/07/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.01.15 NEW ISSUE DD VERF:JLM IPP
REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL32PB5-12		Purchased	No				Each	496.0000		16			
HI 32PB5-12									**				
Hi-Lok Pin													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST263				496					
				M129912				496					
D4867-1		Manufactured	No				Each	0.0000					
D4867-1									**				
Strut													
D4871-1		Manufactured	No				Each	3.0000					
D4871-1									**				
End Fitting													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST124				3					
				112018				3					
D4871-3		Manufactured	No				Each	3.0000					
D4871-3									**				
End Fitting, Eye													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST124				3					
				117329				3					

FF

NOV 28 2014

FF

NOV 28 2014

FF

NOV 28 2014

FF

NOV 28 2014

DQA: _____ Date: _____



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Design									
Doc/Data									
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Picklist Print

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Work Order ID: 123523

123523

Parent Item: D4867-041

D4867-041

Parent Item Name: 206L FWD Leg Assembly

Start Date: 8/07/14

Required Date: 8/07/14

Start Qty: 4.00

Required Qty: 4.00

HL86-5

Purchased

No

Each

1,189.000

16

HI 86-5

FF NOV 28 2014

Collar

Location

Loc Qty

Loc Code

ST263

1189

M128110

12

M128228

29

M129022

200

M129864

948

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26707**

Purchase Order Date 12/3/2014

PO Print Date 12/3/2014

Page Number 4 of 6

Order From :

VC-PL001

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total:

\$4.

10 123523

D4867-041 LEG
ASSEMBLY

12/5/2014

2.00 ✓

\$4.00

\$8.

Yes

12/5/2014

8015-01-7

Line Total:

\$8.

11 121459

D4878-041 LEG
ASSEMBLY

12/5/2014

2.00

\$4.00

\$8.

Yes

12/5/2014

LASER MARKED

Line Total:

\$8.

12 121015

D4880-041 LEG
ASSEMBLY

12/5/2014

2.00

\$4.00

\$8.

Yes

12/5/2014

LASER MARKED

Note:

12/3/2014

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4802-041 LEG ASSEMBLY	2	ALL ITEMS HAVE BEEN LASER MARKED
D4804-041 BIPOD ASSEMBLY	1	
D4834-041 LEG ASSEMBLY	2	
D4835-041 LEG ASSEMBLY	4	
D4836-041 LEG ASSEMBLY	2	
D4836-041 LEG ASSEMBLY	2	
D4866-041 LEG ASSEMBLY	1	
D4866-042 LEG ASSEMBLY	1	
D4866-042 LEG ASSEMBLY	1	
D4867-041 LEG ASSEMBLY	2	SPIS-017
D4878-041 LEG ASSEMBLY	2	
D4880-041 LEG ASSEMBLY	2	
D4881-041 LEG ASSEMBLY	1	
D4881-042 LEG ASSEMBLY	2	